

Date: Wednesday, 29/04/2009 3:02:02 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BEARING		
Job Number	: 47606		Part Number	: D31835		
Estimate Number	: 10091		Drawing Number	: D3183 REV. C1		
P.O. Number	:		Project Number	: N/A		
This Issue	: 29/04/2009	S.O. No. :	Drawing Revision	: C1		
Prsht Rev.	: NC		Material	:		
First Issue	: //	Type	: PURCHASED PARTS			
Previous Run	: 46853		Due Date	: 30/04/2009		Qty: 20
Written By	:		Um:	Each		
Checked & Approved By	: <u>JUL 09.04.29</u>		40			
Comment	: Est: A 03.03.27 New issue KJ/RF					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
		 Comment: PURCHASING Issue P/O: <u>8706</u> <u>C209/04/30</u> Bearing as per Dwg D3183 Single row, deep groove, Conrad type, shielded Possible Supplier: NSK P/N 6800ZZ Certificate of conformity note is required <u>40</u>
2.0	6800ZZ	Bearing
		 Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s) BEARING
3.0	PACKAGING 1	PACKAGING RESOURCE #1
		 Comment: PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure certificate of conformity is attached <u>Peggy (40)</u>
4.0	QC6	DIMENSIONAL CHECK
		 Comment: DIMENSIONAL CHECK <u>509/05/05 (40) contin</u>
5.0	PACKAGING 1	PACKAGING RESOURCE #1
		 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>936</u> <u>9/5/5</u> <u>(40)</u> <u>50</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 29/04/2009 3:02:02 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARING

Job Number: 47606

Part Number: D31835

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



09/05/05 (J)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-05-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

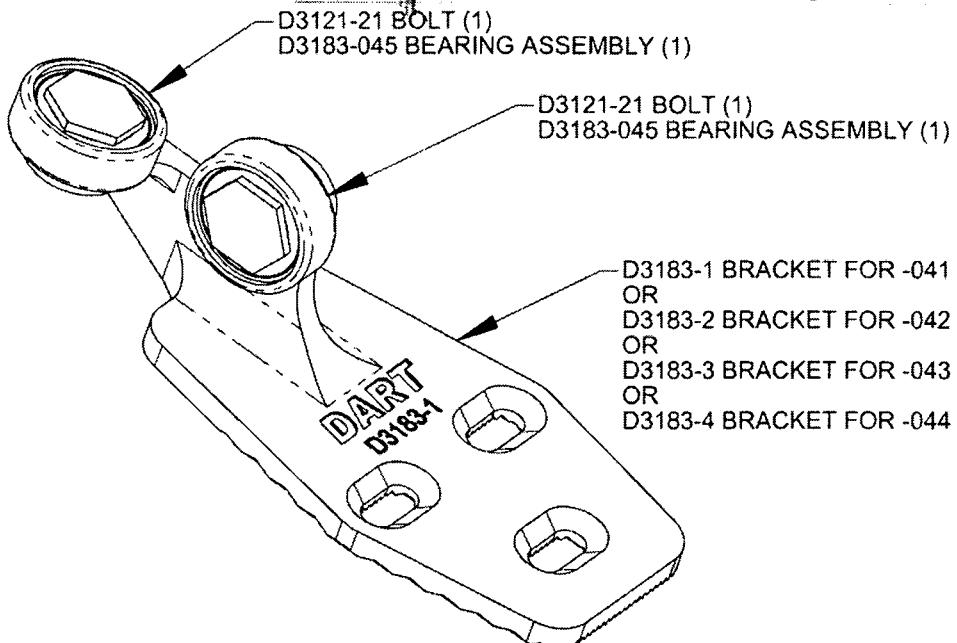
DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C SHEET 1 OF 4
DATE	04.02.17	TITLE	SCALE 1:1

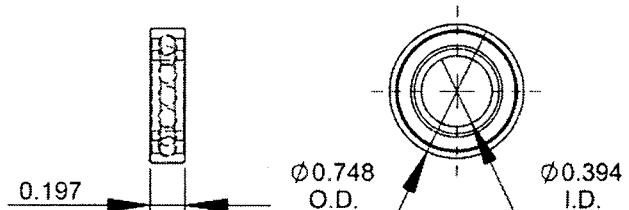
RELEASED
04.02.17

A	03.01.24	NEW ISSUE
B	03.06.17	REMOVE BEARING; 1.012 WS 0.882
C	04.02.17	ADD -045-9; 0.182 WAS 0.431

C1 04.02.17 04.11.07 0.830 WAS C-850

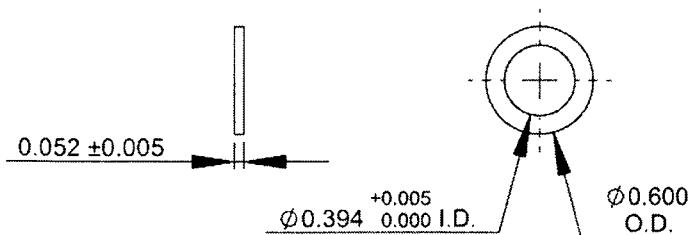


D3183-041 BRACKET ASSEMBLY (SHOWN)
D3183-042 BRACKET ASSEMBLY (OPPOSITE)
D3183-043 BRACKET ASSEMBLY (SIMILAR)
D3183-044 BRACKET ASSEMBLY (SIMILAR)



D3183-5 BEARING: SPECIFICATION CONTROL DRAWING

- 1) SINGLE ROW, DEEP GROOVE, CONRAD TYPE, SHIELDED
- 2) POSSIBLE SUPPLIER: NSK P/N 6800ZZ
- 3) ALL DIMENSIONS ARE IN INCHES



D3183-7 WASHER

SHOP COPY
RETURN TO
UNCONTROLLED COPY
1) MATERIAL: AISI 303 ROUND BAR (M303)
ANNEALED
2) BREAK ALL SHARP EDGES 0.005 TO 0.010
3) TOLERANCES ARE PER DART QSI-018
UNLESS OTHERWISE NOTED WITHOUT NOTICE
4) ALL DIMENSIONS ARE IN INCHES WORK ORDER
NO. 147600

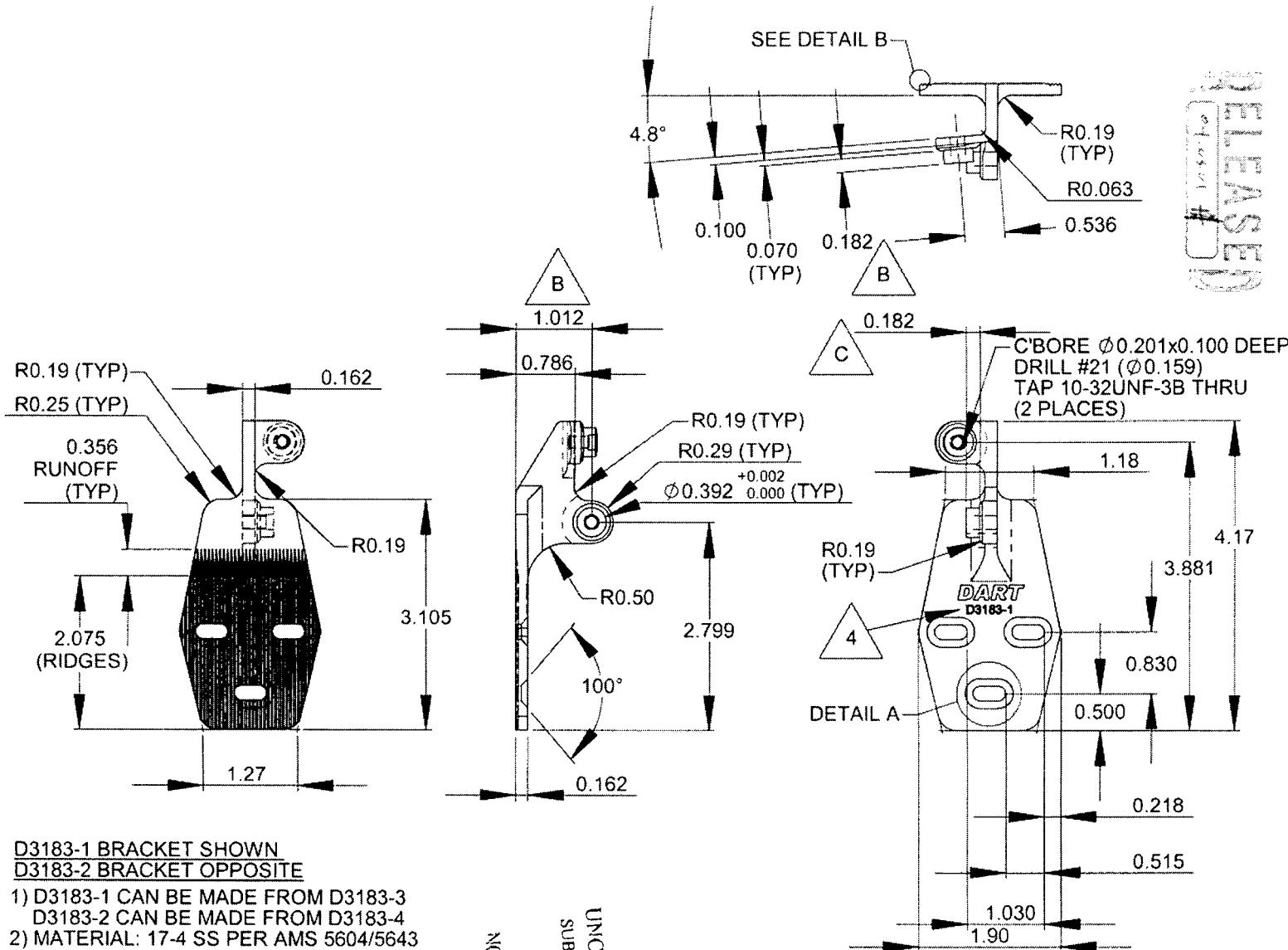
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ACUITY
730

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		DRAWING NO.	
		D3183	
DATE	04.02.17	TITLE	
		BRACKET ASSEMBLY	
		SHEET 2 OF 4	
		SCALE	
		1:2	



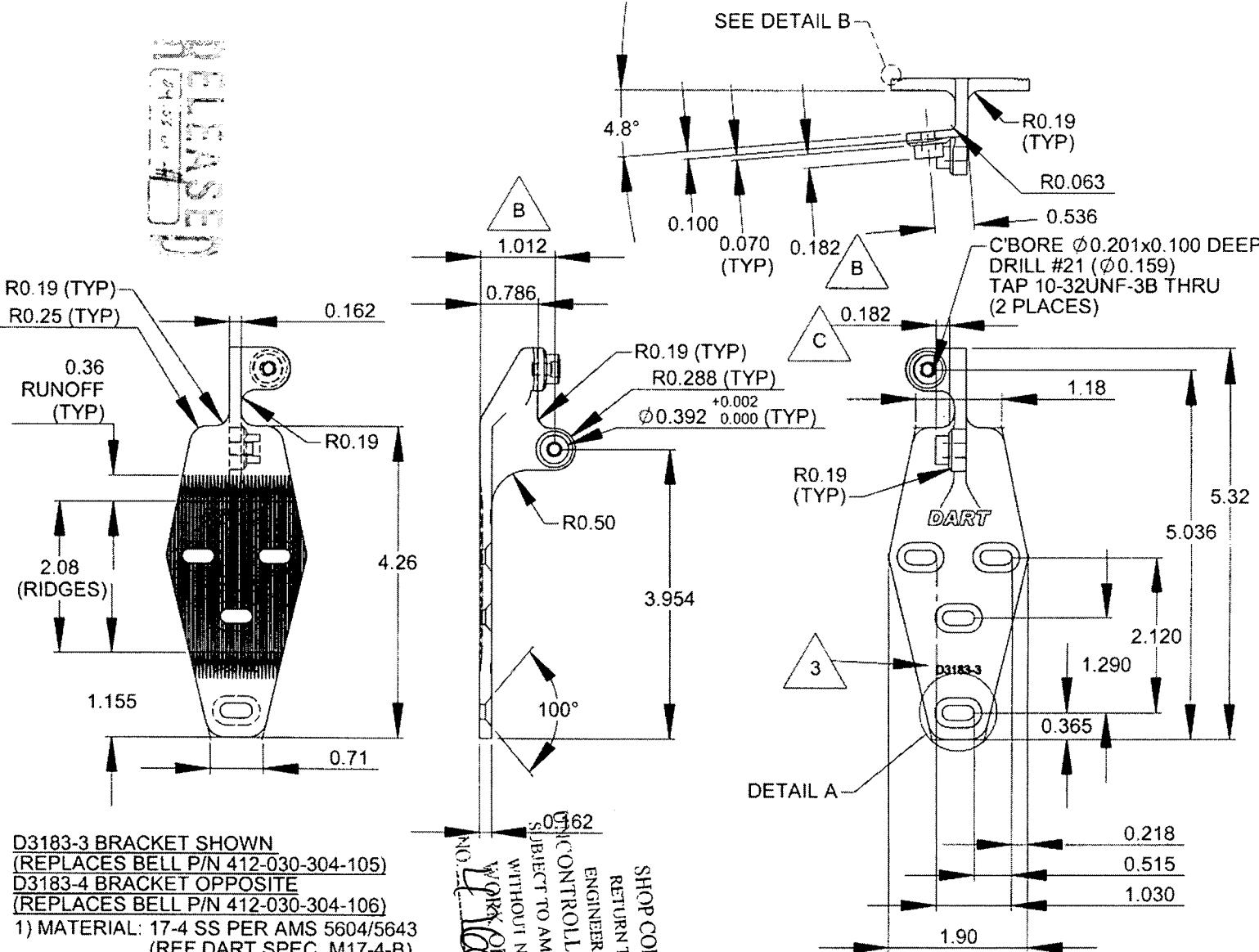
D3183-1 BRACKET SHOWN
D3183-2 BRACKET OPPOSITE

- 1) D3183-1 CAN BE MADE FROM D3183-3
D3183-2 CAN BE MADE FROM D3183-4
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE STRENGTH = 150 ksi
MIN YIELD STRENGTH = 100 ksi
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ENGRAVE DART P/N & LOGO AS SHOWN
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *2/2017*



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04.02.17	D3183		SHEET 3 OF 4
	TITLE	SCALE	
	BRACKET ASSEMBLY	1:2	



D3183-3 BRACKET SHOWN
(REPLACES BELL P/N 412-030-304-105)

D3183-4 BRACKET OPPOSITE

(REPLACES BELL P/N 412-030-304-106)

1) MATERIAL: 17-1 SS PER AMS 5621/5642

1) MATERIAL: 17-4 SS PER AMS 5604/5643

(REF DART SPEC. M17-4-B)

MIN ULTIMATE STRENGTH =

MIN YIELD STRENGTH = 100

2) BREAK ALL SHARP EDGES 0.005 TO 0.01

3) ENGRAVE PART P/N 81000 AS SUCCINIC

3) ENGRAVE DART P/N & LOGO AS SHOWN

4) TOLERANCES ARE PER DART QSI 018 U

5) ALL DIMENSIONS ARE IN INCHES

6. ALL DIMENSIONS ARE IN INCHES

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DATE	04.02.17	D3183	SHEET 4 OF 4

